

Work Order ID 84150

May-04-12 8:51:03 AM

flush

84150

Page 1

Item ID: D3870-1

Revision ID:

Item Name: Base

Start Date: 5/04/12 Start Qty: 2.00

Required Date: 5/07/12 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: *[Signature]*

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start ***NR1***

Stop ***NR2***

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3870

A

100

100

Waterjet

FLOW CNC Waterjet

6061 .250 x 6.00

FLOW WATER JET

Memo

1-Cut as per Dwg D3870

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr edges and holes if necessary

0.00

0.00

2

Ø

Jm / [Signature]
12-5-4

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

2

Ø

Jm / [Signature]
12-5-4

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

8/17/07

(72)

Work Order ID 84150

May-04-12 8:51:03 AM

84150

Page 2

Item ID: D3870-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Base

Start Date: 5/04/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/07/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: Eriel

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

88

12-05-07

12/5/8 DJ

12-05-7

Picklist Print

May-04-12 8:51:02 AM

Page 1

Work Order ID: 84150

Parent Item: D3870-1

Parent Item Name: Base

Start Date: 5/04/12

Required Date: 5/07/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 09-01-20 as per prelim issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X06.000		Purchased	No			100	f	15.2000	0.09	0.18			
6061-T6 Bar .250 x 6.00													

Location

Loc Qty

Loc Code

MAT001

15.2

117379

3.2

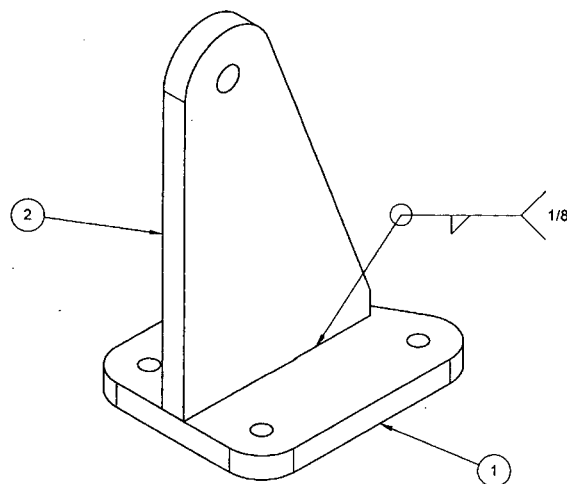
121040

12

117379

JM/ndm
12-5-4

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3870-1	BASE	1
2	D3870-3	RIB	1



D3870-041 FWD LH HARDPOINT

W/O 841150

RELEASED
09/01/11

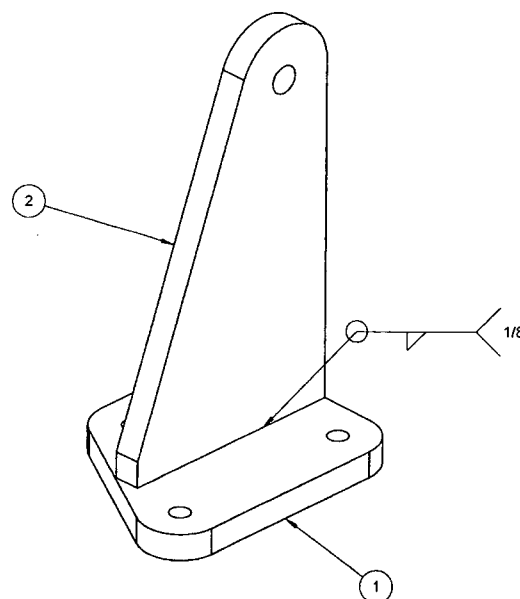
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3870-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs
- 8) WELD PER DART QSI 004

A	NEW ISSUE		08.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.12.11		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3870	REV. A
TITLE MOUNT	SCALE NTS
COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. ANY REPRODUCTION OR DISSEMINATION OF THIS DOCUMENT IS PROHIBITED WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -042
1	D3870-1	BASE	1
2	D3870-3	RIB	1



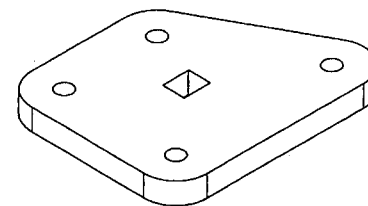
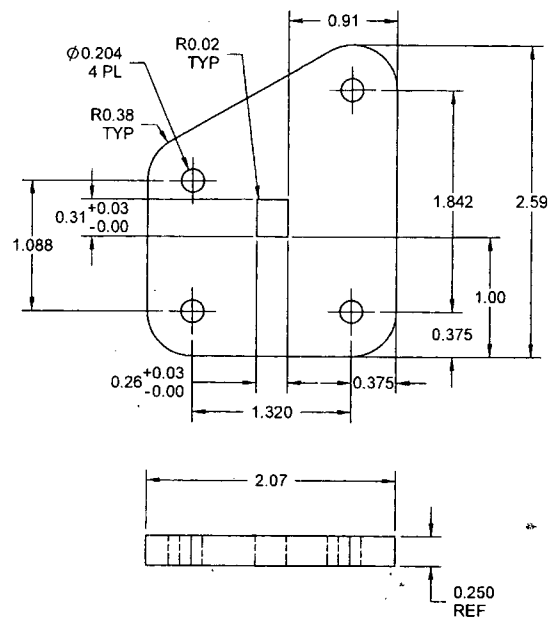
D3870-042 FWD RH HARDPOINT

RELEASED
07/01/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3870-042" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs
- 8) WELD PER DART QSI 004

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3870	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	-NTS
DATE	08.12.11	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3870-1 BASE

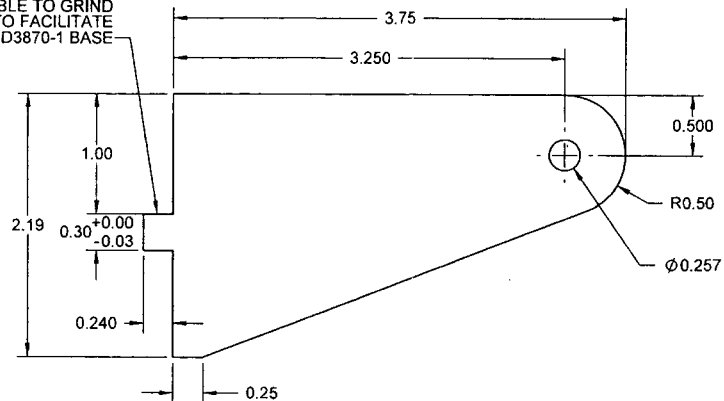
RELEASED
07/01/2011

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.25 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.250)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3870	REV. A
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE MOUNT	SCALE
DE APPR.			NTS
DATE	08.12.11	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

IT IS ACCEPTABLE TO GRIND
CORNERS TO FACILITATE
FITTING TO THE D3870-1 BASE



0.25
REF

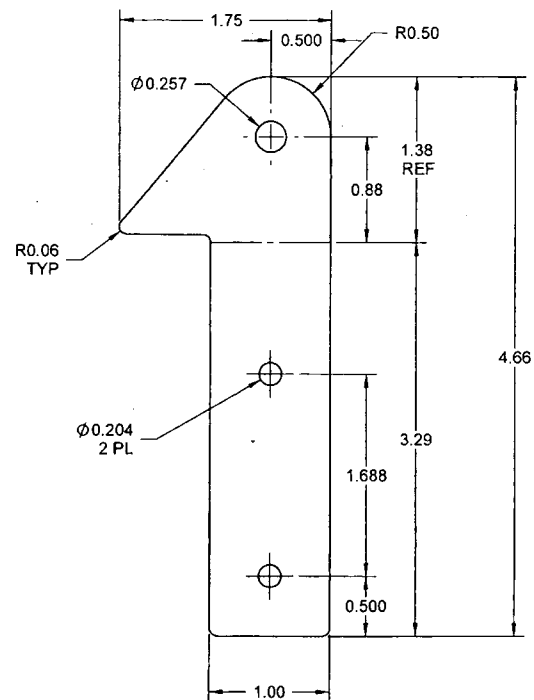
D3870-3 RIB

RELEASED
07/04/11

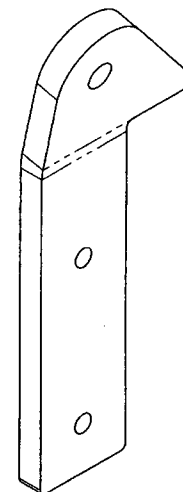
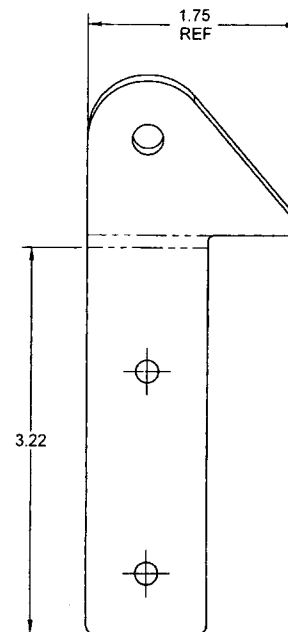
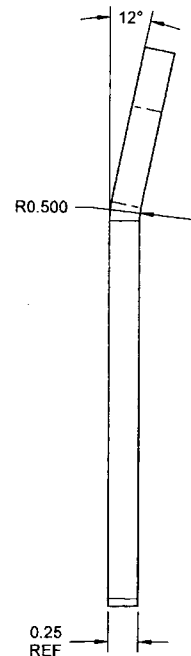
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.25 THICK PER AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.250)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3870	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
DATE	08.12.11	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3870-5F FORWARD UPPER MOUNT FLAT PATTERN



D3870-5 FORWARD UPPER MOUNT
MADE FROM D3870-5F

RELEASED
07/09/11

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.25 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.250)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	<i>ES</i>	DART AEROSPACE LTD	
DRAWN	<i>ES</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ES</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>ES</i>	D3870	SHEET 5 OF 5
APPROVED	<i>ES</i>	TITLE	SCALE
DE APPR.	<i>ES</i>	MOUNT	NTS
DATE	08.12.11	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DART AEROSPACE LTD		Work Order: 84150
Description: Base		Part Number: D3870-1
Inspection Dwg: D3870-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.204	+0.005 -0.001	0.205	✓		Vern	HB-02
0.375	+/- 0.010	0.383	-		Vern	HB-02
1.00	+/- 0.030	1.011	✓		Vern	HB-02
1.842	+/- 0.030	1.842	✓		Vern	HB-02
2.59	+/- 0.030	2.601	✓		Vern	HB-02
0.91	+/- 0.030	0.918	✓		Vern	HB-02
1.088	+/- 0.010	1.092	✓		Vern	HB-02
1.320	+/- 0.010	1.320	✓		Vern	HB-02
0.26	+/- 0.030	0.259	✓		Vern	HB-02
0.375	+/- 0.010	0.380	✓		Vern	HB-02
R0.02	+/- 0.030	0.028	✓		RG	
R0.38	+/- 0.030	0.380	✓		RG	
2.07	+/- 0.030	2.089	✓		Vern	HB-02
0.250	+/- 0.010	0.241	-		Vern	HB-02

Measured by: Jm / [Signature]	Audited by: S	Prototype Approval:	N/A
Date: 12-5-4	Date: 12/5/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	